



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6305G19151-3G

Job Sheet 172402



01/14

Part No: RBW6305G19151-3G

Job Qty: 3 ea

Part Name: Guide Fan Drive Quill Seal Housing Installer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G19151-3G Rev B IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs		4/16/18	0.00	0.00	Purchasing		AC 18/04/18
110	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging2		AC 18/04/18
120	QC	3 pcs		4/16/18	0.00	0.00	QC6		38
130	Packaging	3 pcs		4/16/18	0.00	0.00	Packaging3		18-04-18 7 03
140	QC21-FG	3 Ea		4/16/18	0.00	0.00	QC21	mt. 18/04/18	GA 104 03

Part Op 100 - Issue PO to ARROW TECH MACHINE WORKS P/O: 035084 MANUFACTURE RBW6305G19151-3GAS PER
Descriptions: DWG -Certificate of conformity is required

FEB 22 2018

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21

9-80

APR 18 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G19151-3GP	Guide Fan Drive Quill Seal Housing Installer	3 (1 ea)	100-Purchasing	5061464

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6305G19151-3GP	3	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



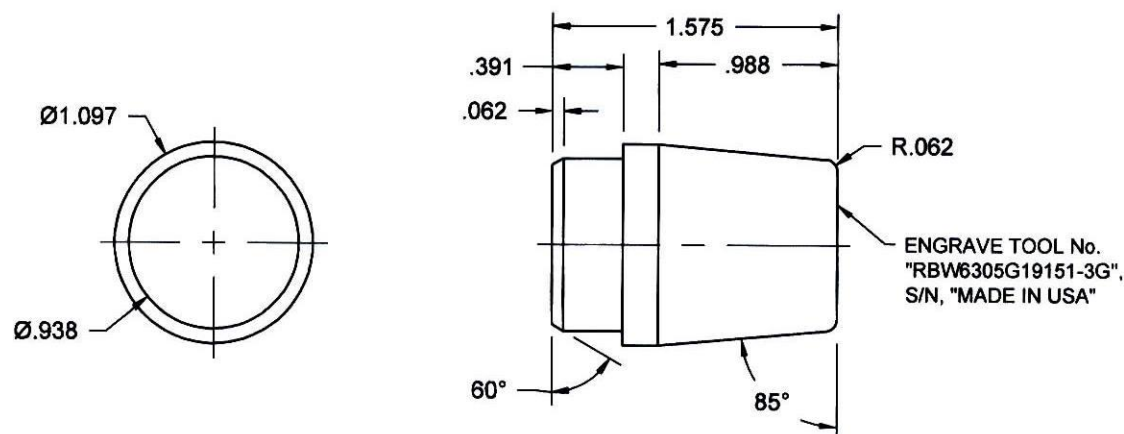
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description Wor _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																			
Job No: 172402 Mtg Date: 04/16/18		Change No: _____ Operation: _____ Revision: _____ Serial No/Batch: S061487 PART NO: RBW6305G19151-3G Guide Fan Drive Quill Seal Housing Installer			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="5" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width: 15%;">Environment</td> <td style="width: 15%;">☐</td> <td style="width: 15%;">No Re-verification</td> <td style="width: 15%;">☐</td> <td style="width: 15%;"></td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> <td></td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> <td></td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td></td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> <td></td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td></td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td></td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td></td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td></td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td></td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td></td> </tr> </tbody> </table>					Root Cause					Environment	☐	No Re-verification	☐		Design	☐	Operator	☐		Doc/Data	☐	Offset/Setup	☐		Equip/Tooling	☐	Supplier	☐		Handling/Pre	☐	Training	☐		Material	☐	Use for Testing	☐		Internal Transport	☐	Poor Information	☐		Tribal Knowledge	☐	Rushing	☐		LOA	☐	Product Improvement	☐		Substation	☐	Process Improvement	☐		Past Expiry Date	☐	Manufacturing Process	☐		Misidentified	☐	Past Due	☐	
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OTHER : _____																																																																					

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	ADDED MISSING Ø.938 DIMENSION PER G.E.	5/9/11	RJC	RW
B	CHD TOOL NAME WAS FAN DRIVE QUILL SEAL HOUSING GUIDE IS GUIDE, FAN DRIVE QUILL SEAL HOUSING INSTALLER TO MATCH PARTS MANUAL.	11/1/13	RJC	RW



NOTES

1. ALSO SOLD WITH KIT RBW6305G01531-3G, BOX TWO RBW6305G19731-3G.

RED BARN MACHINE	
GUIDE, FAN DRIVE QUILL SEAL HOUSING INSTALLER	
DWG NO. RBW6305G19151-3G	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	METRIC REF.
DECIMALS	XXmm ± .1mm
XXX ± .005	FRACTIONS ± 1/32
XX ± .01	ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 2-4-11
SHEET 1 of 1	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
				1	GUIDE	6061 RND. BAR	Ø1-1/8 x 1-3/4	
ASSY #								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By 	
				Lead hand / Supervisor Approval Verification 	
				QC / QA Coordinator Approval 	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER : _____ _____ _____							
Misidentified	☐	Past Due								



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PURCHASE ORDER PO039084

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
				3G Rev. 1							
Line Item Note job# 172416											
15	RBW6305G14631-3GP			Tail Rotor Drive Quill Seal Housing Remover As Per Dwg RBW6305G14631-3G Rev. 1A	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$1,205.32/Ea	\$3,615.96
Line Item Note job# 172415											
16	RBW6305G14831-3GP			Tail Rotor Drive Quill Lip Seal Remover As Per Dwg RBW6305G14831-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$922.80/Ea	\$2,768.40
Line Item Note job# 172414											
17	RBW6305G16031-3GP			Drive Quill Seal Housing Remover As Per Dwg RBW6305G16031-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$981.65/Ea	\$2,944.95
Line Item Note job# 172413											
18	RBW6305G18331-3GP			Ecs Drill Quill Lip Seal Remover As Per Dwg RBW6305G18331-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$534.40/Ea	\$1,603.20
Line Item Note job# 172412											
19	RBW6305G18631-3GP			Ecs Drive Quill Housing Remover As Per Dwg RBW6305G18631-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$1,043.33/Ea	\$3,129.99
Line Item Note job# 172411											
20	RBW6305G19231-3GP			Puller Rotor Brake Adapter Flange Remover As Per Dwg RBW6305G19231-3G Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$740.19/Ea	\$2,220.57
Line Item Note job# 172410											
21	RBW6305G19151-3GP			Guide Fan Drive Quill Seal Housing Installer As Per Dwg RBW6305G19151-3G Rev. B	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$132.32/Ea	\$396.96
Line Item Note job# 172402											
22	RBW6305G16231-3G-1P			Handle As Per Dwg RBW6305G16231-3G-1 Rev. 2	Firmed	4/16/18	3 Ea	0 Ea	3 Ea	\$368.38/Ea	\$1,105.14

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ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039084

Dated: 4/12/2018

Our Order / Job No:10AWT

Order Qty:3

Part Name: GUIDE

Part Number: RBW6305G19151-3G

Lot Size: N/A Ship Date: 4/12/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number:RBW6305G19151-3G

Rev:B

Material Size and Type: 6061 ALUMINUM

Material Specifications: ALUMINUM- ASTM B221

Heat Treatment: N/A

Plating/Finish:CLEAR ANODIZE SPEC: MIL-A-8625F, TYPE II, CLASS I

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 4/12/18

Signed: Herbert M. Salts

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